

Work Order ID 100657

Thursday, April 25, 2013 4:21:58 PM

100657

Page 1

Item ID: D4653-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vent Manifold Assembly

Start Date: 4/25/2013 Start Qty: 6.00

6

Cust Item ID:

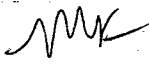

Required Date: 4/26/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: Date:  Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr**Revision Nbr**

D4653

REV A

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

170

0.00

170

Small Fab

Memo

0.00

Small Fab

INSTALL FITTING ASSEMBLY WITH LUBE AS PER DWG

BATCH #: M118348

5/3/25



180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

27
13-426

6

Work Order ID 100657

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100657

Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Vent Manifold Assembly

Start Date: 4/25/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

PPP 99 482

0.00

Packaging

13/4/26 (6)

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

13/5/16 JJ

MF

13-4-26

Picklist Print

Thursday, April 25, 2013 4:21:57 PM

Page 1

Work Order ID: 100657
 Parent Item: D4653-041
 Parent Item Name: Vent Manifold Assembly

Start Date: 4/25/2013 Required Date: 4/26/2013
 Start Qty: 6.00 Required Qty: 6.00

Comments: IPP REV:A 12.06.08 NEW ISSUE DD VERF:EC
 ASSY JLM VERIFIED BY:DD IPP REV B 12-09-20 REVISED

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4653-3 Collar		Manufactured	No			110	Each	19.0000					

¹
 B 93065 x 6 S 13/4/25

Location	Loc Qty	Loc Code
ST117	12	
93065	12	
ST118	7	
91366	7	

D4653-045 Fitting Assembly		Manufactured	No			170	Each	17.0000	2	12			
-------------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST118	17	
91367	12	
98549	5	

B 98549 x 5
 B 91367 x 7

S 13/4/25

8

7

6

5

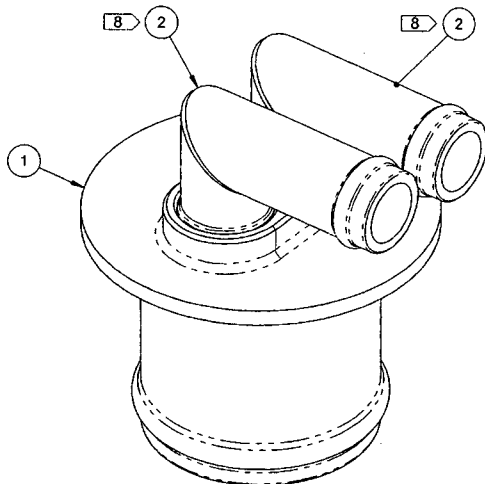
4

3

2

1

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4653-041	VENT MANIFOLD ASSEMBLY
1	1	D4653-3	COLLAR
2	2	D4653-045	FITTING ASSEMBLY
3	A/R	LUBRICANT	MOLKOYE 55 O-RING GREASE



D4653-041 VENT MANIFOLD ASSEMBLY

RELEASED
2012-11-05
W

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.35 lbs
- 8) APPLY A LAYER OF MOLYKOTE 55 O-RING GREASE TO O-RING PRIOR TO INSTALLING D4653-045

A	NEW ISSUE	MB	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	HF		
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	AV		
APPROVED	W		
DE APPR.	W		
DATE	12.07.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4653 REV. A
SHEET 1 OF 6
TITLE VENT MANIFOLD ASSY SCALE NTS

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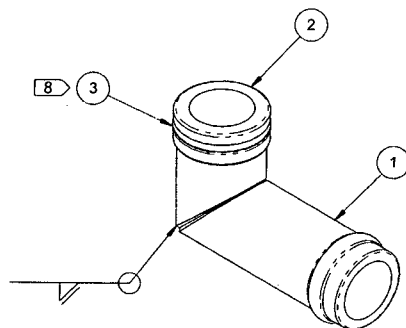
4

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1

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4653-045	FITTING ASSEMBLY
1	1	D4653-7	LARGE FITTING
2	1	D4653-9	SMALL FITTING
3	1	D4654-3	O-RING



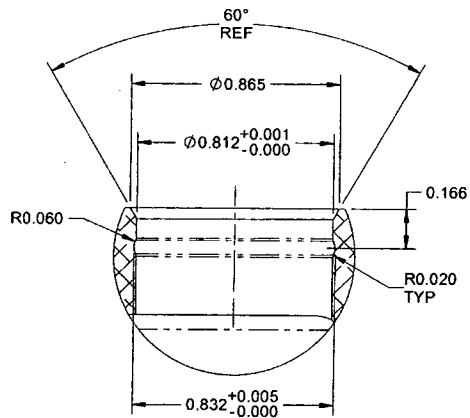
D4653-045 FITTING ASSEMBLY

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2012-11-05
MP

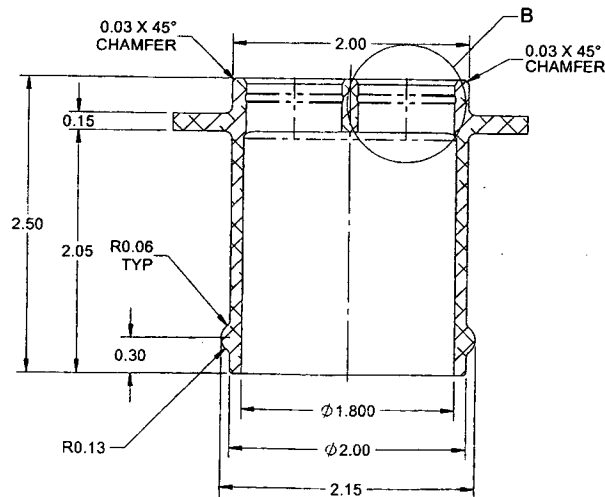
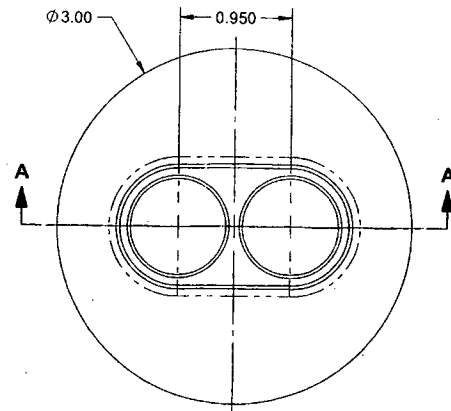
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) WELD PER QSI 004
- 9) CHEMICAL CONVERSION COAT PRIOR TO INSTALLING O-RING

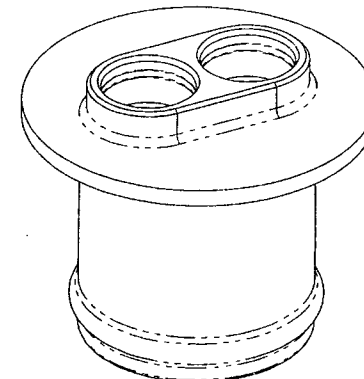
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4653	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VENT MANIFOLD ASSY	NTS
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SECTION B-B
SCALE 2X, 2 PL



SECTION A-A



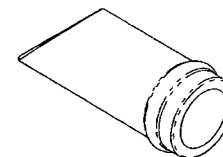
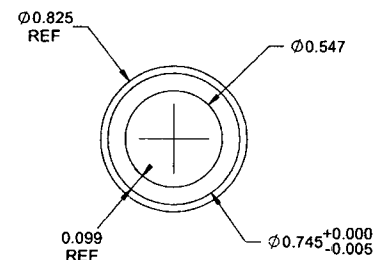
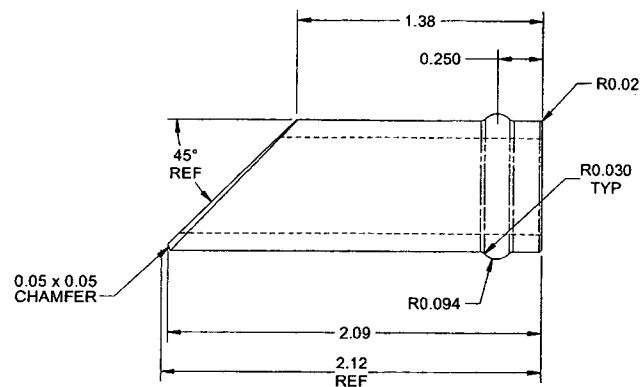
D4653-3 COLLAR

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

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2012-11-05
WMO

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MFG. APPR.	AB	D4653	SHEET 3 OF 6
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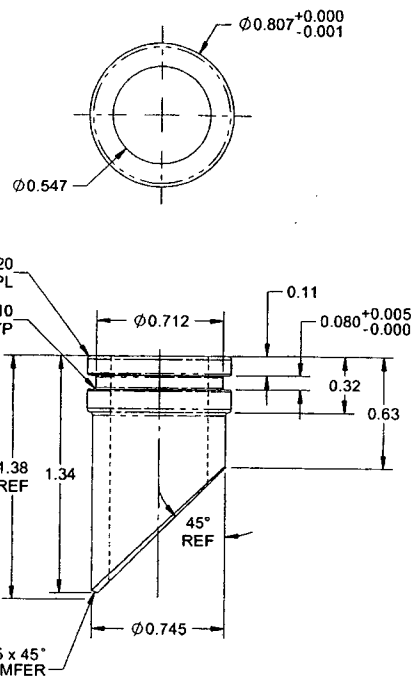
D4653-7 LARGE FITTING

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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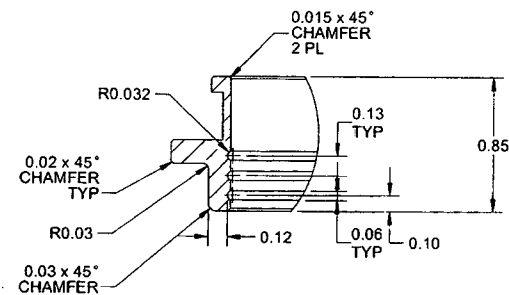
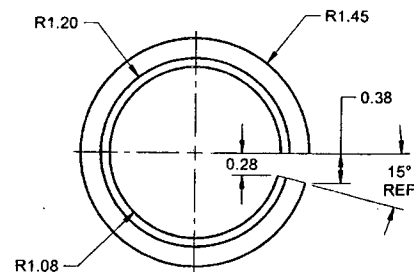
D4653-9 SMALL FITTING

NOTES:

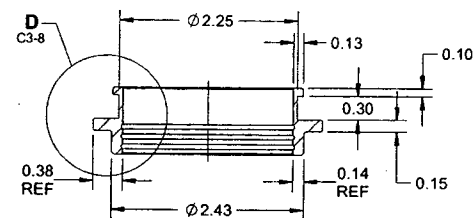
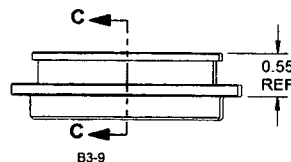
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

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DETAIL D C4-9
SCALE 2X



SECTION C-C C6-9

D4653-11 CLAMP

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
REF DART SPEC M-DELRIN-B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.032 lbs

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